

44

20.88

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	19534
<b>Description:</b> Long Step Assembly - High Skid, RH		<b>Part Number:</b>	704A 41 640 007
D350-591-212			
<b>Dwg:</b> D3070 Rev. A1		<b>Qty:</b>	105
RF 02-11-13		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	10	03.08.27	10 5
2	DC	Photocopy bluefile and type labels per PPP 704A 41 640 007 <del>CHG001</del> <del>CHG 001</del> <del>Wk 42</del>	10	03.10.07	10 5
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3070 using cutting table setup DT8185-2A <b>Pick:</b> Qty Part Number Description Batch 1 D2622-120C Extrusion B18809 <b>Ensure wall thickness is 0.070 to 0.090</b>	ml	04-02-02	5
4	GA	Drill extrusion per Dwg D3070 using Jig DT8680 for rivets.	ml	04-02-02	5
5	GA	Deburr	ml	04-02-02	5
6	QC5	Inspect work to Step 5	B	04-02-02	5
7	WA	Bevel end for welding <b>FWD ONLY</b>	M	04/02/06	5
8	WA	Weld Support using Jig DT8681, weld Fwd End Plate per QSI 004 & Dwg D3070 <b>Pick:</b> Qty Part Number Description Batch 1 D3063-1 Support B19555 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066	M	04/02/06	5
9	GA	Grind End Plate flush	M	04/02/06	5
10	QC9	Inspect weld and work to Step 9	B	04-02-11	5
11	FP	Chemical conversion coat as per QSI 005 4.1	2	04-02-13	5
12	GA	Assemble Leg Assembly as per Dwg D3070. D3066-1 are done with Step Leg Assy, don't add to the BOM. RF 03-01-10 <b>Pick:</b> Qty Part Number Description Batch 1 D3065-041 Step Leg Assy B19557 2 D3066-1 Spacer B19557 16 MS20600AD4W4 Rivet M13767	B	02/04/15	5
13	QC5	Inspect work to step 12	M	04/02/19	5
14	WA	Bevel Aft end for welding	M	04/02/19	5
15	WA	Inspect for foreign object per QSI 024	M	04/02/19	5
16	WA	Weld Aft End Plate per QSI 004 & Dwg D3070 <b>Pick:</b> Qty Part Number Description Batch 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066	M	04/02/19	5

BR 04-02-25 DR

CANCEL RF 03-01-16  
UNDER REVIEW  
03-06-06 RF  
See David

RELEASED  
02/11/01 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	19534
<b>Description:</b> Long Step Assembly – High Skid, RH D350-591-212	<b>Part Number:</b>	704A 41 640 007
<b>Dwg:</b> D3070 Rev. A1	<b>Qty:</b>	105
Page 2 of 2		

17	GA	Grind End Plate flush	50	04/02/19	5																																																				
18	QC9 & 5	Inspect work to Step 17 – Check dimension <del>110.56"</del> from Dwg D3070 110.71" RF 02.11.13	18	04.02.20	5																																																				
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	2	04.02.23	5																																																				
20	FP	Wing Walk per Dwg D3070 and QSI 005 4.4	M	04.02.23	5																																																				
21	QC3	Inspect Powder Coat and Wing Walk	1	04.02.24	5																																																				
22	KP	<b>Pick: Packing Kit</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4✓</td><td>D2182B035</td><td>Rubber Cushion</td><td>B19540</td></tr><tr><td>8✓</td><td>D2274</td><td>Radius Block</td><td>B20207</td></tr><tr><td>2✓</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B18972</td></tr><tr><td>2✓</td><td>D3064-1</td><td>Clamp</td><td>B20123</td></tr><tr><td>1✓</td><td>D3070-041</td><td>Support Assy</td><td>B20056</td></tr><tr><td>4✓</td><td>D3080-1</td><td>Clamp</td><td>B19559</td></tr><tr><td>2✓</td><td>AN3-35A</td><td>Bolt</td><td>M13943</td></tr><tr><td>10✓</td><td>AN4-11A</td><td>Bolt</td><td>M13735</td></tr><tr><td>4✓</td><td>AN960JD10</td><td>Washer</td><td>M13719</td></tr><tr><td>20✓</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>2✓</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M14019</td></tr><tr><td>10✓</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13276</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4✓	D2182B035	Rubber Cushion	B19540	8✓	D2274	Radius Block	B20207	2✓	D2856-400-720	Abrasion Strip	B18972	2✓	D3064-1	Clamp	B20123	1✓	D3070-041	Support Assy	B20056	4✓	D3080-1	Clamp	B19559	2✓	AN3-35A	Bolt	M13943	10✓	AN4-11A	Bolt	M13735	4✓	AN960JD10	Washer	M13719	20✓	AN960JD416	Washer	M13719	2✓	MS21042L3	Nut (or -3)	M14019	10✓	MS21042L4	Nut (or -4)	M13276	CR.	04.02.24	5
Qty	Part Number	Description	Batch																																																						
4✓	D2182B035	Rubber Cushion	B19540																																																						
8✓	D2274	Radius Block	B20207																																																						
2✓	D2856-400-720	Abrasion Strip	B18972																																																						
2✓	D3064-1	Clamp	B20123																																																						
1✓	D3070-041	Support Assy	B20056																																																						
4✓	D3080-1	Clamp	B19559																																																						
2✓	AN3-35A	Bolt	M13943																																																						
10✓	AN4-11A	Bolt	M13735																																																						
4✓	AN960JD10	Washer	M13719																																																						
20✓	AN960JD416	Washer	M13719																																																						
2✓	MS21042L3	Nut (or -3)	M14019																																																						
10✓	MS21042L4	Nut (or -4)	M13276																																																						
23	QC4	Inspect 100% Kit for Completeness on the W/O	1	04.02.24	5																																																				
24	PK	Package for shipping as per PPP 704A 41 640 007	1	04.02.24	5																																																				
25	AC	Cost / part 243.62	545	04.02.25	5																																																				
26	DC	Close W/O 243.62 Inspect Level 21	KJ	04.02.26	5																																																				

Rev	Date	Change	Revised By	Approved
A	02.11.01	New issue	KJ RF	
A1	03.01.14	110.71" WAS 110.56" ; Dwg. Rev. A1	RF	
A2	03.07.16	D3194-041 WAS D3070-041 ; CHG002	RF	

UNDER REVIEW

03.06.06 RF

See David

CANCEL RF 03.01.16

RELEASED  
02/11/02

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**NOTE:** Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 27, 2003  
02:05 pm

Work Order No	: 0019534	Department Code:	
Project Name	: *704A 41 640 007	Burden Flags	: NNNNNNN
Project For	: wk344	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *704A 41 640 007	Invoice Number	:
Description	: Heli-Access-Step, Long RH	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 10 5	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 08-27-03	Actual Margin	: 0.000%
Est Finish Date	: 11-06-03		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Testing Hours	: 0.00	0.00	0.00		
Testing Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
SubContract Hours	: 0.00	0.00	0.00		
SubContract	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00